

CLIPPEDIMAGE= JP404232378A

PAT-NO: JP404232378A

DOCUMENT-IDENTIFIER: JP 04232378 A

TITLE: METHOD FOR FORMING INJECTION PORT OF FUEL INJECTION VALVE

PUBN-DATE: August 20, 1992

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APPL-NO: JP02409308

APPL-DATE: December 28, 1990

INT-CL (IPC): F02M061/18;B24B005/48

ABSTRACT:

PURPOSE: To eliminate burr of a chamfering part, and finish that chamfering part accurately by chamfering the inner peripheral edge of an injection port with a rough grinding wheel, and enlarging a diameter of the injection port, and finishing the chamfering part with a finishing grinding wheel.

CONSTITUTION: In the case of chamfering the inner peripheral edge 11a of an injection port 11 formed in the tip of a valve body 3 of a fuel injection valve, a conical rough grinding wheel 21 is inserted from the upper into the valve body 3, and this rough grinding wheel 21 is rotated at a predetermined speed, and while the tip 21a of the rough grinding wheel 21

is pushed to the inner peripheral edge 11a of the injection port 11 to grind the inner peripheral edge 11a of the injection port 11 for chamfering. Next, a cylindrical grinding wheel 23 is used to grind the inner peripheral surface 11b of the injection port 11, and enlargement of diameter of the injection port 11 and the inspection of the static flow characteristic are repeated to adjust the static flow characteristic. Thereafter, the inner peripheral edge 11a of the injection port 11 is finished by a rough finishing grinding wheel 27. Burr of the chamfering part is thereby eliminated to finish that chamfering part accurately.

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